

Date: Monday, 22/10/2007 2:17:12 PM
User: Linda Lacelle

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 35295-1
Estimate Number : 12578
P.O. Number :
This Issue : 22/10/2007 S.O. No. :
Prsht Rev. : NC
First Issue : 11 Type : SMALL / MED FAB
Previous Run : 35029

Drawing Name : ARM

Part Number : D3560041

Drawing Number : D3560 UNDER REVIEW

Project Number : N/A

Drawing Revision : C

Material :

Due Date : 29/10/2007

Qty: 14 Um: Each

Written By :

Checked & Approved By :

Comment :

Est Rev: A New Issue 07.05.24 EC
est rev B ECN 987 07.10.09 EC verified by: DD

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6B0500X05000

6061-T6 Bar .50" x 5.0"



Comment: Qty.: 1.4648 f(s)/Unit Total: 20.5065 f(s)
6061-T6 Bar 0.50" x 5.00"

Batch: 1105950

2.0

BAND SAW

BAND SAW :



Comment: BAND SAW

Cut blanks 16.750" long

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA693 Rev: AA & Dwg D3560 Rev: C

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

User:

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35295

Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 14.0000 Each(s)

PLATE

3 35331

335331 ✓

SP 08-07-11

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad) *h SP*
- 2- set up bracket and arm on jig *h SP*
- 3- preheat bracket and arm with torch *h SP*
- 4- clean before welding with brush *h SP*
- 5- set up machine to 135 amps *h SP*
- 6- weld across bottom and top ends *h SP*
- 7- reheat with torch (*LO 9*) *h SP*
- 8- on one side weld from bottom to top half way *h SP*
- 9- same for other side (half way) *h SP*
- 10- from half way point weld the rest of the first side (ease off pedal near end) *h SP*
- 11- same for remaining side (ease off pedal near end) *h SP*

SP 08-07-14

SP 08-07-14

SP 07-11-29 2

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

SP 08-07-14 (4)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35295

Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



4/8

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BE/WH 08/07/15

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



AS

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

D2808

Spacer



08-07-15

(VCD)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 14.0000 Each(s)

Spacer

batch: B 35330

08/07/16

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

08/07/16

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WH

08/07/16 (x8)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



08.07.21

4

Comment: FINAL INSPECTION/W/O RELEASE

08/07/21

Job Completion

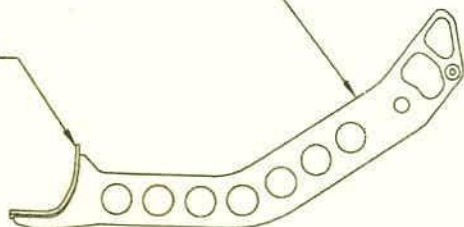


08-07-21

W03595

D3560-1 ARM (-041, SHOWN)
OR D3560-2 ARM (-042, OPPOSITE)

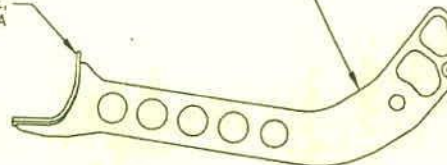
D3592-1 PLATE,
SEE DETAIL A



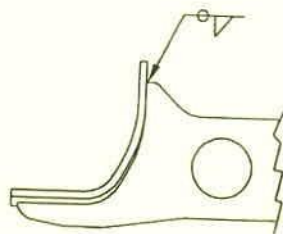
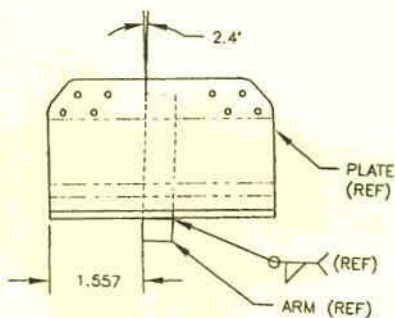
D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)

D3560-3 ARM (-043, SHOWN)
OR D3560-4 ARM (-044, OPPOSITE)

D3592-1 PLATE,
SEE DETAIL A



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

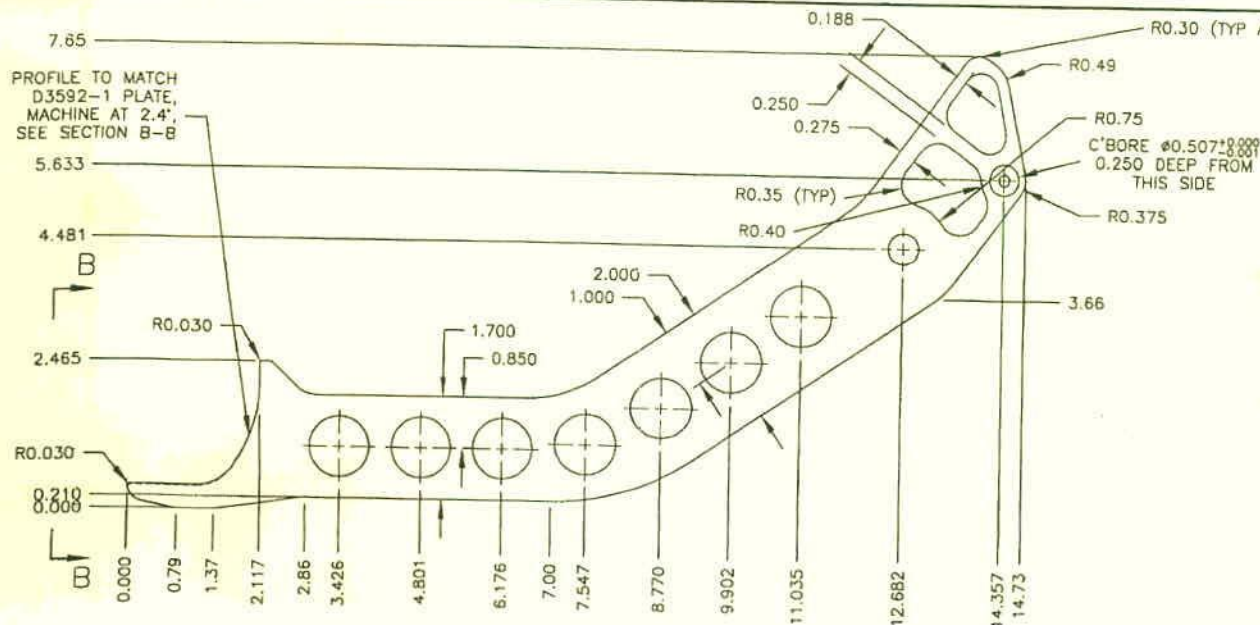
RELEASED
07.06.21

UNDER REVIEW
07.06.21

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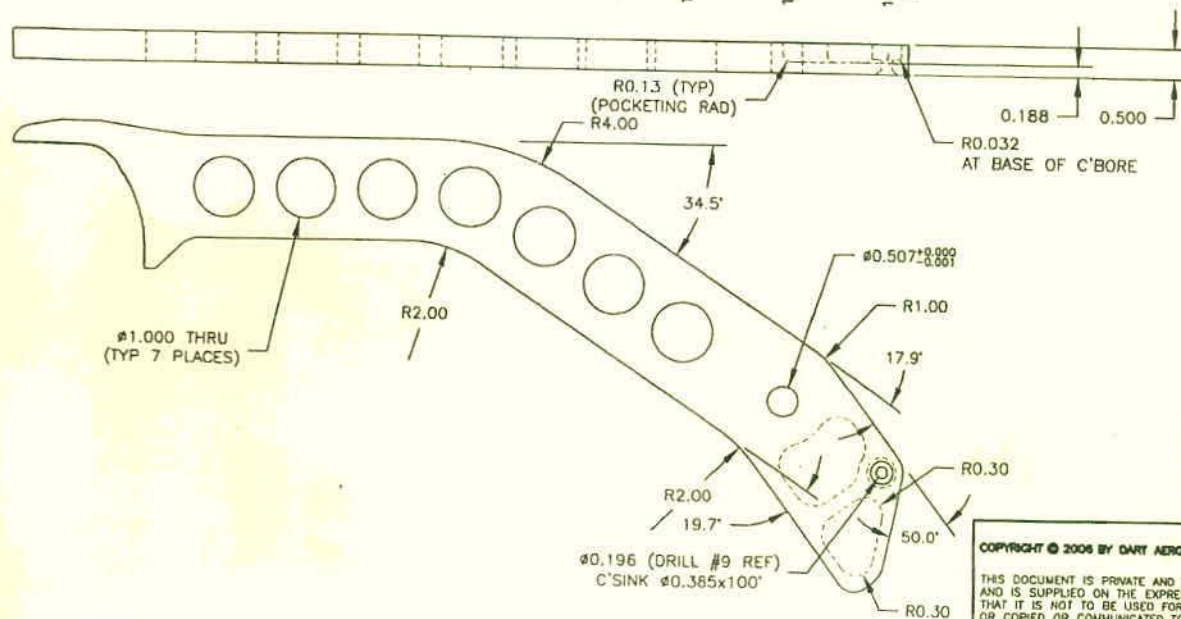
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C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	<i>qp</i>	DRAWN BY <i>qp</i>
CHECKED	<i>qp</i>	APPROVED <i>qp</i>
DATE	07.06.19	TITLE
		DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
		DRAWING NO. D3560
		SCALE 1:4
		REV. C SHEET 1 OF 3

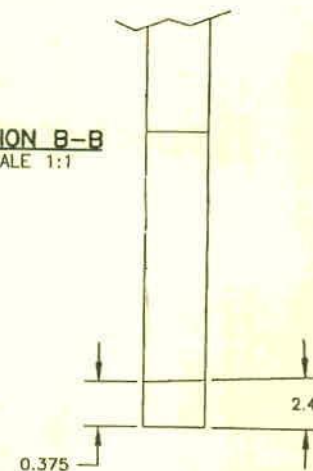


D3560-1 ARM (SHOWN). D3560-2 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



SECTION B-B
SCALE 1:1

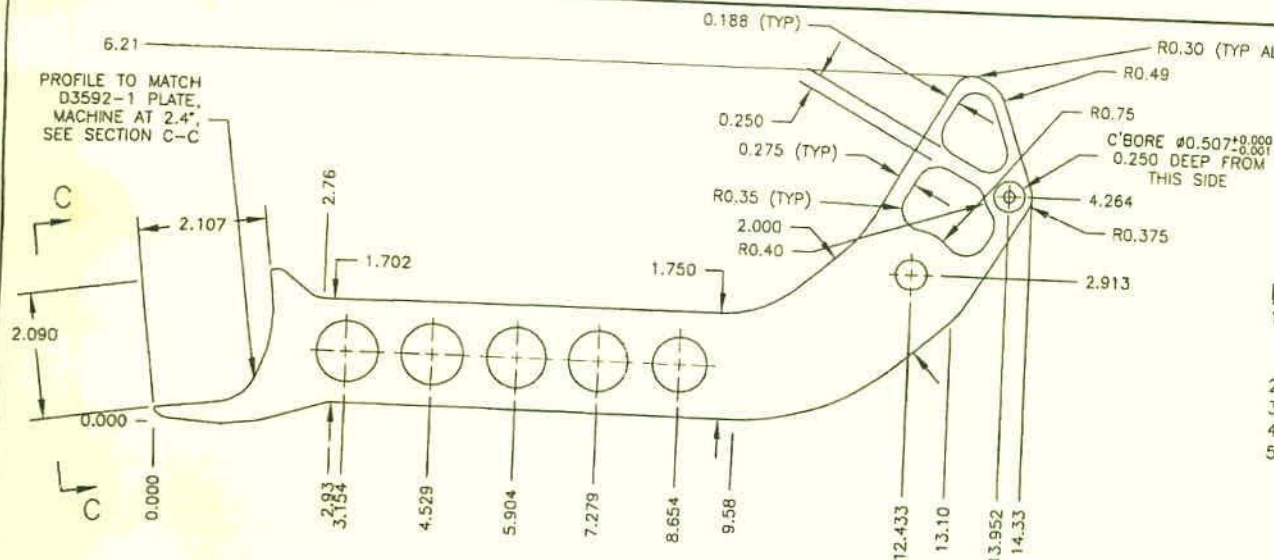


RELEASED
07.06.29

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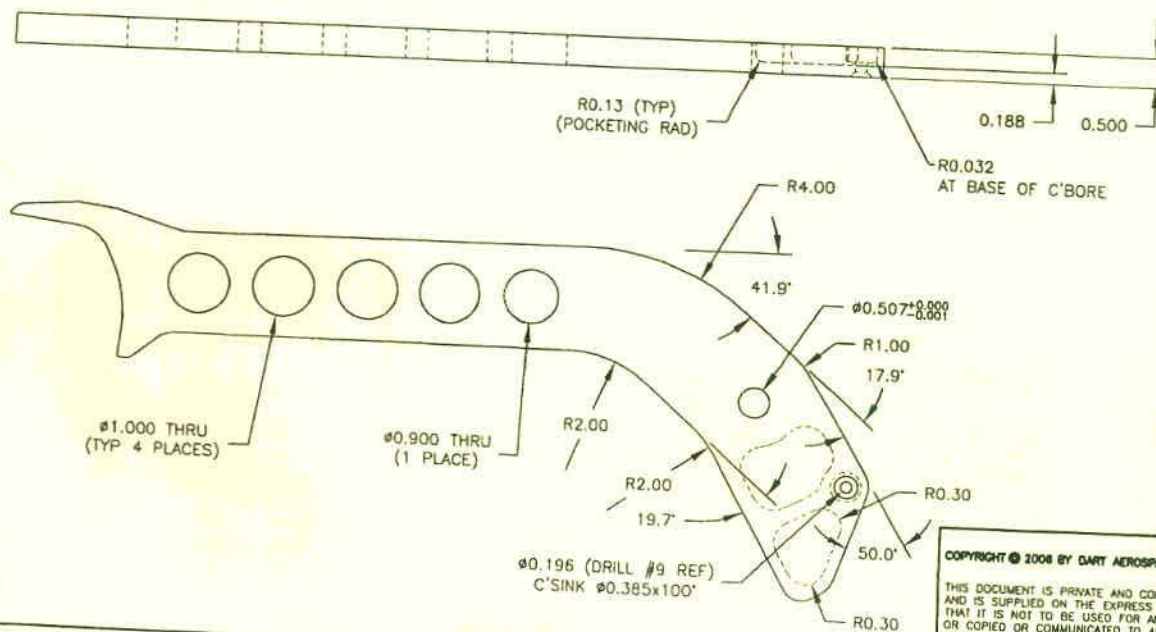
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DESIGN	qo	DRAWN BY	qo	DART	DART AEROSPACE LTD. WARRIMUR, ONTARIO, CANADA
CHECKED	h	APPROVED	h	DRAWING NO.	D3560
DATE	07.06.19	TITLE	ARM WELDMENT	REV. C	SHEET 2 OF 3
				SCALE	1:2

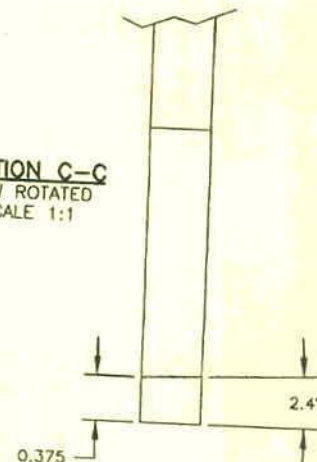


D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC.
M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



SECTION C-C
VIEW ROTATED
SCALE 1:1



RELEASED
07.06.19

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CHECKED	th	APPROVED	th	DRAWING NO.	D3560
DATE	07.06.19	TITLE	ARM WELDMENT	REV. C	SHEET 3 OF 3
				SCALE	1:2

